

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017940**Date Inspected:** 11-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xiang Feng Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Barrier Rail

PCMK: E2-SB5-021-130,131

Welder: 215397

WPS-B-T-2132-3

PCMK: E2-SB1D-024-019,050

Welder: 216872

WPS-B-T-2132-3

PCMK: E2-SB1-046-001~012

Welder: 203710

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WPS-B-T-2132-3

PCMK: E2-SB1-036-001~012

Welder: 215082

WPS-B-T-2132-3

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xiang Feng Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Anchor Plate

PCMK: AP3032-001-798,799

Welder: 066596

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-606,607

Welder: 068924

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-338,339

Welder: 067500

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-632,633

Welder: 066041

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

PCMK: AP3032-001-968,969

Welder: 066359

WPS-B-T-2233-TC-U4b-F/ WPS-B-T-2233-TC-P4-F

Components: Floor Beam

PCMK: FB3343-001-393

Welder: 068445,067942

WPS-B-T-2232-TC-U4b-F

PCMK: FB3343-001-342

Welder: 066912,200009

WPS-B-T-2232-TC-U4b-F

PCMK: FB3343-001-395

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Welder: 066401
WPS-B-T-2232-TC-U4b-F

PCMK: FB3343-001-096
Welder: 066236
WPS-B-T-2232-TC-U4b-F

PCMK: FB3343-001-114
Welder: 066734
WPS-B-T-2232-TC-U4b-F

This QA Inspector observed the following work in progress for Bay 2.
ZPMC was using the Submerged Arc Welding (SAW) process.
ZPMC QC is identified as Xiang Feng Feng.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Vertical Plate
PCMK: VP3015-001-042
Welder: 045265
WPS-B-T-2221-B-L2C-S-2

Bay 3

This QA Inspector observed the following work in progress for Bay 3.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Longitudinal Diaphragm
PCMK: LD3041-001-026
Welder: 050242
WPS-B-T-2233-TC-U5-F

PCMK: LD3040-001-016
Welder: 055564
WPS-B-T-2233-TC-U5-F

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Shu Yang Hua.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

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Components: Barrier Rail
PCMK: W2-SB10-037-20~25
Welder: 215689
WPS-B-T-2132-3

Bay 8

This QA Inspector observed the following work in progress for Bay 8.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xu Xian Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Bike Path
PCMK: BK004A5-059-083
Welder: 500405
WPS-B-T-2132-3

This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; BK004A5-056, Item number 4 of NWIT tracker document # 07315 and BK4ASD1-056, BK4ASD1-054, BK004A-058, Item Number 2, 3, 4, of NWIT tracker document# 07314.

Bay 9

This QA Inspector observed ZPMC QC Inspector Mr. Zhang Hai Jun performed ASTM A 325 Bolt tension test for ¾" diameter, 2" long bolts with Lot No DHG 60631 on Service plat form SP4-01, SP7-01, SP8-01 at Bay 9.

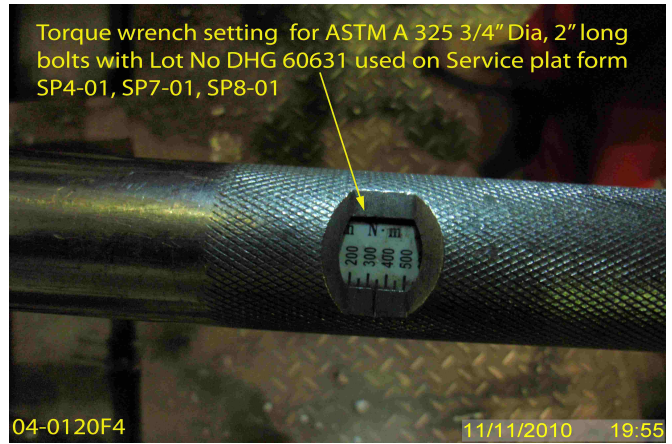
ZPMC used Click type torque wrench setting was 350 N/M, ZPMC QC tested 1bolt per each connection.

Also QA Inspector confirmed Torque wrench calibration dates and wrench settings prior to testing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
